

## PATENT SPECIFICATION

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(54) AQUEOUS ALCOHOLIC, FOAM-GROWTH-  
 CONTROLLING  
 PRINTING INK COMPOSITIONS

(71) We, CONGOLEUM CORPORATION a corporation organized and existing under the laws of the State of Delaware, United States of America, of 777 East Wisconsin Avenue, Milwaukee, State of Wisconsin, United States of America, do hereby declare the invention, for which we pray that a patent may be granted to us, and the method by which it is to be performed, to be particularly described in and by the following statement:—

The present invention relates to improved aqueous-alcoholic, foam-growth-controlling printing ink compositions of use in chemical embossing techniques and to processes of using such aqueous-alcoholic, foam-growth-controlling printing ink compositions in the chemical embossing of floor, ceiling, or wall coverings; desk, table, and counter tops; coated or impregnated fabrics; upholstery and clothing materials; book covers; automobile interiors; and like articles.

Chemical embossing techniques have been used widely in industry in the manufacture of floor, ceiling, and wall coverings; desk table, and counter tops; coated and impregnated fabrics; and like articles, as more particularly described in United States Patents 3,293,094 and 3,293,108 which issued December 20, 1966 to R. F. Nairn et al.

Such chemical embossing techniques have normally involved coating a base material, such as an asbestos sheet, with a substantially uniform layer of a resinous material, such as polyvinyl chloride or other resinous material. A foaming or blowing agent, such as azodicarbonamide, is normally uniformly dispersed in the resinous material and is adapted, upon subsequent heating to a sufficiently elevated temperature; to decompose and to liberate gaseous decomposition products to expand and create the foamed, blown resinous product.

One aspect of such chemical embossing techniques has comprised the printing of

selected, predetermined areas of the surface of the heat-foamable resinous material, prior to the heating, with a foam-growth-controlling printing ink composition which is capable of affecting and changing the foam-growth of those selected, predetermined areas when the heat-foamable resinous materials are subsequently heated to the required elevated temperature.

Such foam-growth-controlling printing ink compositions have contained either: (1) agents for inhibiting or suppressing the decomposition of the foaming or blowing agents to thus decrease the resulting expanding gaseous action on the foamable resinous materials and to correspondingly decrease the foam-growth in the selected, predetermined areas to which they are applied; or (2) agents for catalyzing or accelerating the decomposition of the foaming or blowing agents to thus increase the resulting gaseous action on the foamable resinous materials and to correspondingly increase the foam-growth in the selected, predetermined areas to which they are applied.

As a consequence, the surface of the resulting, foamed or blown resinous materials have been given an embossed or relief pattern effect containing relatively higher areas or lands and relatively lower areas or valleys, thus providing excellent surface contrast.

The foam-growth-controlling printing ink compositions have thus contained both: (1) the foam-growth-controlling agents; and (2) the pigments, inks, dyes, or other coloring materials, whereby the resulting embossed of relief pattern effects have been made to coincide very accurately and very precisely with the ink-printing pattern, thus creating excellent visual and tactile effects which are in substantially perfect alignment and registry at all times.

More specific details and particulars of such chemical embossing techniques may be found in the United States Patents

previously referred to herein and such details and particulars are incorporated herein by reference thereto.

5 Although a number of organic solvent-based foam-growth-controlling printing ink compositions have been used previously in such chemical embossing manufacturing techniques, and have proved to be relatively successful therein, it is always  
10 desired to improve upon existing commercial and industrial techniques. Organic solvent-based printing inks are relatively expensive, are usually very difficult to remove or clean from printing  
15 equipment, are occasionally not adaptable for use with conventional commercial printing equipment, are often flammable or have relatively low flash points which are unfortunately conducive to dangerous or  
20 hazardous conditions, frequency cause significant waste, ecological, or pollution problems, and sometimes required costly and time-consuming solvent-recovery programs.

25 It is therefore a principle purpose and object of the present invention to provide improved aqueous-alcoholic, foam-growth-controlling printing ink compositions for use with chemical embossing processes,  
30 which compositions are relatively less expensive, are normally easier to remove and clean from printing ink equipment, are more adaptable for use with conventional printing equipment, are less flammable and  
35 have higher or effectively no flash points, do not create dangerous or hazardous conditions, are less prone to create significant waste, ecological, or pollution problems, and normally do not require  
40 costly or time-consuming solvent recovery programs.

45 In accordance with the invention there is provided an aqueous-alcoholic, foam-growth-controlling printing ink composition having a pH of from 8 to 12 of use in the chemical embossing of heat-foamable and expandable resinous materials comprising: (1) from 1 to 15% of a  
50 foam-growth-controlling chemical agent which is soluble or dispersible in said aqueous-alcoholic, foam-growth-controlling printing ink composition and sufficiently stable therein as to retain its foam-growth-controlling properties; (2)  
55 from 1 to 9% of a water-soluble or water-dispersible alcohol having from 1 to 6 carbon atoms; (3) from 1 to 11% of a pH controlling or buffering agent capable of creating or maintaining the pH of said  
60 aqueous-alcoholic, foam-growth-controlling printing ink composition in the range of from 8 to 12; (4) from 30 to 75% of an aqueous printing ink composition; and (5) from 10 to 40% of added water,  
65 sufficient to adjust the viscosity of said

aqueous-alcoholic, foam-growth-controlling printing ink composition to desired levels for printing on said heat-foamable and expandable resinous materials. Such an aqueous-alcoholic, foam-growth-controlling printing ink composition is capable of being applied to the surface of heat-foamable and expandable resinous materials in selected, predetermined areas in processes wherein the benefits and the advantages of chemical embossing manufacturing techniques may be realized without suffering many of the detriments and disadvantages previously encountered in the use of organic solvent-based printing ink compositions. 70  
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The amount of the foam-growth-controlling agent used in the formulation of the printing ink composition depends upon the degree of the embossing or relief effect which is desired or required. 85

The present invention will be described in greater particularity with respect to benzotriazole as the foam-growth-controlling agent. The agent may be a pentatomic heterocyclic ring compound containing three nitrogen atoms and two carbon atoms in the pentatomic heterocyclic ring. 90

A more complete list of applicable and utilizable foam-growth-controlling agents includes aminotriazoles such as 3 - amino - 1,2,4 - triazole; 4 - amino - 1,2,4 - triazole; 1 - amino - 1,2,3 - triazole; 1 - amino - 1,3,4 - triazole; 1,2,4 - triazole; 1,2,3 - triazole; and mixtures of such triazoles. 95  
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Such foam-growth-controlling agents must be sufficiently soluble or dispersible in the aqueous-alcoholic printing ink compositions and they must be sufficiently stable therein as not to be convertible, through hydrolysis or alcoholysis or otherwise, into other chemical forms in which they lose their foam-growth-controlling properties and characteristics. 105  
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The improved aqueous-alcoholic, foam-growth-controlling printing ink compositions also contain an alcohol which is water-soluble or water-dispersible, contains from 1 to 6 carbon atoms, and is present in an amount of from 1% to 9% by weight, based on the total weight of the aqueous-alcoholic, foam-growth-controlling printing ink composition. 115

Although such an alcohol is, of course, organic in nature, and is preferably an alkylalcohol, its concentration of only from 1% to 9% is to be contrasted to organic-solvent-based printing ink compositions of the prior art which normally contained organic solvents such as methyl ethyl ketone, methyl isobutyl ketone, xylol, toluol etc., in concentrations of from 45% to 7% by weight. 120  
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Although the present invention will be 130

described in greater particularity with respect to isopropanol as the preferred alkyl alcohol, a more complete list of applicable and utilizable alcohols includes: methanol, ethanol, 1-propanol, 1-butanol, 2-pentanol, hexanol.

The improved foam-growth-controlling printing ink compositions also contain a pH controlling or buffering agent which is present in an amount of from 1% to 11% by weight, based on the total weight of the foam-growth-controlling printing ink composition.

Although the present invention will be described in greater particularity with respect to ammonia or 2-dimethylaminoethanol as the preferred pH controlling or buffering agents, a more complete list of applicable and utilizable agents which are capable of creating or maintaining a pH in the range of from 8 to 12 includes: boric acid-sodium tetraborate (borax) yielding a buffered pH of about 8.5; sodium tetraborate yielding a buffered pH of about 9.2; boric acid-sodium hydroxide yielding a buffered pH of about 9.2; sodium bicarbonate - sodium carbonate yielding a buffered pH of about 10.2; disodium phosphate-sodium hydroxide yielding a buffered pH of about 11.5; etc. The concentration of these buffering agents is normally in the range of about 0.1 molar, unless specifically indicated otherwise. Other alkylaminoalcohols are also of use and include: 2-diethylaminoethanol; 2-methylamino-ethanol; 2-ethylaminoethanol.

Care should be taken to maintain the pH of the aqueous-alcoholic foam-growth-controlling printing ink compositions within the indicated pH ranges of from 8 to 12. In the event that ammonia or other relatively volatile material is used to establish or to maintain the desired pH range, care should be taken and additional amounts of the ammonia or other alkaline materials or the other relatively volatile materials should be supplied, if and when needed, to prevent the pH from dropping below a value of about 8.

As used herein, the term "ammonia" is not intended to include pure ammonia such as the pure gas or the compressed or cooled liquid ammonia ( $\text{NH}_3$ ) but is intended to include solutions of ammonia in water, i.e. aqua ammonia having from 25% to 30%  $\text{NH}_3$  or from 24° to 27° Baumé.

The specific water-base gravure printing ink which is employed does not relate to the essence of the present invention, other than the fact that it must be aqueous. It can be a pigment dispersion in a latex emulsion or a solution, and water-soluble acrylic or melamine resins, for example, may be used. The remainder of the formulation of the printing ink composition is a solution.

Specific suitable and utilizable printing ink compositions are: AIY-33 Yellow, AIR-39 Red, AIW34 White, AIB-35 Phthalo Blue, Aqueous Printing Inks from Custom Chemical Company. RBH-991B001 White, RBH-991B022 Lemon Chr. Yellow, RBH-991B003 Phthalo Blue, RBH-991B004 Furnace Black, etc. from Inmont Corporation and GV-21647 Vynaprint Black Conc. from Polychemical Corporation. These printing ink compositions may be used as is, or various combinations thereof may be employed to obtain various color and shade possibilities. The expression "printing ink composition" as used herein is also intended to cover pigment-free printing compositions containing an extender such as AIC-28 Clear Aqueous Printing Ink from Custom Chemical Company.

These aqueous printing ink compositions are present in amounts of from 30% to 75% by weight, based on the total weight of the aqueous-alcoholic, foam-growth-controlling composition.

Inasmuch as these aqueous printing ink compositions are commercially available and used as aqueous solutions or dispersions having specified concentrations of coloring materials by solids therein, the actual or real solids content of the ink, pigment, dye or other coloring material is actually in the range of from 3% to 45% of the total weight of the foam-growth-controlling printing ink composition. Naturally, aqueous printing ink compositions which are commercially available with pH ranges of from about 8 to 12 are preferred, inasmuch as such will obviate the necessity of adjusting their pH values to such a range, prior to their use.

Water is normally included in added amounts of from 10% to 40% in order to bring the consistency of the viscosity of the aqueous-alcoholic, foam-growth-controlling printing ink composition to desired ranges for best handling by the printing equipment. Such viscosities are normally in the range of from about 20 to about 60 seconds, Zahn 3 cup.

The invention will be further illustrated in greater detail by the following specific Examples. It should be understood, however, that, although these Examples may describe in particular detail some of the more specific features of the present invention, they are given for purposes of illustration and are not to be construed as limitative of the broader aspects of the present invention.

#### EXAMPLE I

The aqueous-alcoholic, foam-growth-controlling printing ink composition comprises:

5	Benzotriazole	6.5%	EXAMPLE II		Benzotriazole	1.0%	65	
	Isopropanol	3.8%			Isopropanol	1.5%		
	2-Dimethylaminoethanol	4.1%			2-Dimethylaminoethanol	3.0%		
	Added water	22.8%			Added Water	31.7%		
	AIY-33 Yellow Aqueous Printing Ink; acrylic resin base; 30% pigments solids; 48.2% total non-volatiles; remainder water		62.8%	AIY-33 Yellow Aqueous Printing Ink		62.8%		
10	EXAMPLE III							70
	Benzotriazole	9.8%						
	Isopropanol	5.7%						
	2-Dimethylaminoethanol	6.2%						
	Added Water	33.2%						
15	AIY-33 Yellow Aqueous Printing Ink		45.1%	EXAMPLE IV			75	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	Ammonia 26° Baumé; 29.4% NH <sub>3</sub>	4.1%						
	Added Water	22.8%						
20	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE V			85	
	Aminotriazole	6.5%						
	Isopropanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
25	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE VI			90	
	Benzotriazole	6.5%						
	Methanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
30	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE VII			100	
	Benzotriazole	6.5%						
	Ethanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
35	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE VIII			105	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	2-Diethylaminoethanol	4.1%						
	Added Water	22.8%						
40	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE IX			110	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
45	AIR-39 Red Aqueous Printing Ink; acrylic resin base; 3.5% pigments solids; 30.5% total non-volatiles; remainder water		62.8%	EXAMPLE X			115	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
50	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE XI			120	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
55	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE XII			125	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
60	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE XIII			130	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE XIV			135	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE XV			140	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE XVI			145	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE XVII			150	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE XVIII			155	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE XIX			160	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE XX			165	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE XXI			170	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE XXII			175	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE XXIII			180	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE XXIV			185	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE XXV			190	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE XXVI			195	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE XXVII			200	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE XXVIII			205	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE XXIX			210	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE XXX			215	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE XXXI			220	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE XXXII			225	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE XXXIII			230	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE XXXIV			235	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE XXXV			240	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE XXXVI			245	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE XXXVII			250	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE XXXVIII			255	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE XXXIX			260	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE XL			265	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE XLI			270	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE XLII			275	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE XLIII			280	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE XLIV			285	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE XLV			290	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE XLVI			295	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE XLVII			300	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE XLVIII			305	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE XLIX			310	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE L			315	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE LI			320	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE LII			325	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE LIII			330	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE LIV			335	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE LV			340	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE LVI			345	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE LVII			350	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE LVIII			355	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE LIX			360	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE LX			365	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE LXI			370	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE LXII			375	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE LXIII			380	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE LXIV			385	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE LXV			390	
	Benzotriazole	6.5%						
	Isopropanol	3.8%						
	2-Dimethylaminoethanol	4.1%						
	Added Water	22.8%						
	AIY-33 Yellow Aqueous Printing Ink		62.8%	EXAMPLE LXVI			395	
	Benzotriazole	6.5%						

## EXAMPLE X

	Benzotriazole	6.5%
	Isopropanol	3.8%
	2-Dimethylaminoethanol	4.1%
5	Added Water	22.8%
	AIW-34 White Aqueous	
	Printing Ink; acrylic resin	
	base; 30.0% pigments solids;	
	48.2% total non-volatiles;	
10	remainder water	62.8%

## EXAMPLE XI

	Benzotriazole	6.5%
	Isopropanol	3.8%
	2-Dimethylaminoethanol	4.1%
15	Added Water	22.8%
	AIB-35 Phthalo Blue Aqueous	
	Printing Ink; acrylic resin	
	base; 7.0% pigments solids;	
	total non-volatiles 31.0%;	
20	remainder water	62.8%

## EXAMPLE XII

	Benzotriazole	6.5%
	Isopropanol	3.8%
	2-Dimethylaminoethanol	4.1%
25	Added Water	22.8%
	AIC-28 Clear Extender Aqueous	
	Printing Ink; acrylic resin	
	base; 0% Pigments solids;	
	total non-volatiles 28.6%;	
30	remainder water	62.8%

Although several specific Examples of the inventive concept have been described, the same should not be construed as limiting the broader aspects of the present invention which include other equivalents features and materials, as set forth and defined in the appended claims.

## WHAT WE CLAIM IS:—

1. An aqueous-alcoholic, foam-growth-controlling printing ink composition having a pH of from 8 to 12 of use in the chemical embossing of heat-foamable and expandable resinous materials comprising: (1) from 1 to 15% of a foam-growth-controlling chemical agent which is soluble or dispersible in said aqueous-alcoholic, foam-growth-controlling printing ink composition and sufficiently stable therein as to retain its foam-growth-controlling properties; (2) from 1 to 9% of a water-soluble or water-dispersible alcohol having from 1 to 6 carbon atoms; (3) from 1 to 11% of a pH controlling or buffering agent capable of creating or maintaining the pH of said aqueous-alcoholic, foam-growth-controlling printing ink composition in the range of from 8 to 12; (4) from 30 to 75% of an aqueous printing ink composition; and (5) from 10 to 40% of added water,

sufficient to adjust the viscosity of said aqueous-alcoholic, foam-growth-controlling printing ink composition to desired levels for printing on said heat-foamable and expandable resinous materials.

2. A printing ink composition as defined in Claim 1 wherein said foam-growth-controlling chemical agent is benzotriazole.

3. A printing ink composition as defined in Claim 1 wherein said foam-growth-controlling chemical agent is an aminotriazole.

4. A printing ink composition as defined in Claim 1 wherein said alcohol is isopropanol.

5. A printing ink composition as defined in Claim 1 wherein said alcohol is methanol.

6. A printing ink composition as defined in Claim 1 wherein said alcohol is ethanol.

7. A printing ink composition as defined in Claim 1 wherein said pH controlling or buffering agent is 2-dimethylaminoethanol.

8. A printing ink composition as defined in Claim 1 wherein said pH controlling or buffering agent is 2-diethylaminoethanol.

9. A printing ink composition as defined in Claim 1 wherein said pH controlling or buffering agent is ammonia.

10. A printing ink composition as defined in Claim 1 wherein said foam-growth-controlling chemical agent is a pentatomic heterocyclic ring compound containing three nitrogen atoms and two carbon atoms in the pentatomic heterocyclic ring.

11. A process for chemically embossing heat-foamable and expandable resinous materials which comprises: applying to selected, predetermined portions of the surface of heat-foamable and expandable resinous materials an aqueous-alcoholic, foam-growth-controlling printing ink composition according to any one of the preceding claims and heating said heat-foamable and expandable resinous materials whereby said selected, predetermined portions to which said aqueous-alcoholic, foam-growth-controlling printing ink composition was applied attain heights differing from and contrasting with those other portions to which said aqueous-alcoholic, foam-growth-controlling printing ink composition was not applied.

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